

Date: Monday, 18/08/2008 10:21:33 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BEAM ASSEMBLY		
Job Number	: 41268			Part Number	: D3173041		
Estimate Number	: 10407			Drawing Number	: D3173 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 18/08/2008	S.O. No.	:	Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 21/08/2008 Qty: 2 Um: Each		
Previous Run	: 37157						
Written By	:						
Checked & Approved By	: <u>JUL 08.8.18</u>						
Comment	: Est. A 02.12.05 New issue KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6TR40X20W125	6061-T6 Rect Tube 4.0 x 2.0 x .125w	
		Comment: Qty.: 4.9219 f(s)/Unit Total : 9.8438 f(s) 6061-T6 Rect Tube W.125	
		Material: 6061-T6 (QQ-A-200/8) Rect. Tube 4" x 2" x 0.125 thick (M6061T6TR4.0x2.0W125) 109025	
		Batch <u>M109025</u>	<u>JL 08/08/28</u>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blank: 56" long Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1	<u>JL 08/08/28</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1	<u>H.A 08/08/30</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>H.A 08/08/30</u>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>S 08/09/10</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3173-041 PAR #: 11A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 08/09/25
 D130-701-041 QA: N/C Closed: D Date: 08/09/25

NCR: 41268		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/30	3.0	Bad origin on Y axis The person before me forgot to remove .00" from the edge finder	J 08/08/30	SCRAP TUBE C Qty 1. No Reply	J.A 08/08/30	C 08/08/30	J 08/08/30	S 08/08/30
		hole one off on one side						

NOTE: Date & initial all entries

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Job Number: 41268		Part Number: D3173041	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
Comment: SMALL & MEDIUM FAB RESOURCE 1		N.A 08/08/30	
Deburr			
7.0	QC8	SECOND CHECK 	
Comment: SECOND CHECK		S. October (C)	
8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
Comment: SMALL & MEDIUM FAB RESOURCE 1			
Drill Ø0.316" holes as per Dwg D3173			
C'sink holes as per Dwg D3173		FF 08-09-11 (1)	
9.0	QC5	INSPECT WORK TO CURRENT STEP 	
Comment: INSPECT WORK TO CURRENT STEP		S. October (C)	
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 	
Comment: HAND FINISHING RESOURCE #1			
Chemical Conversion Coat as per QSI 005 4.1		M.F. 08/09/16 (1)	
11.0	D3178041	Nut Plate 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)			
Nut Plate			
Pick K10017. Install Nut Plate as per Dwg D3173. D3178-041 is included in K10017 BOM.			
Pick:			
Qty	Part Number	Description	Batch
2	D3178-041	Nut Plate	B24895B
12.0	MS20601AD4W4	Rivet 	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)			
Rivet			
Pick:			
Qty	Part Number	Description	Batch
8	MS20601AD4W4	Rivet	19278
		FF 08/09/18 (1)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BEAM ASSEMBLY		
Job Number: 41268		Part Number: D3173041		
Job Number:				
Seq. #:	Machine Or Operation:	Description :		
13.0	QC5	INSPECT WORK TO CURRENT STEP		
Comment: INSPECT WORK TO CURRENT STEP		S 08/08/19 ④		
14.0	POWDER COATING	POWDER COATING		
		M 108523		
Comment: POWDER COATING		IX		
Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3				
Ensure Nut Plate thread is covered.				
START TIME:	12:00			
OVEN TEMPERATURE:	320°			
FINISH TIME:	12:30	m-1 08/09/19		
15.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION		
		E 08/09/19 ②		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION				
16.0	D3175041	Mounting Lug		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)				
Mounting Lug				
Assemble per Dwg D3173. Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.				
MISSING				
Pick:		②		
Qty	Part Number	Description	Batch	
2	D3175-041	Mtg Lug	M24895C	B05025
17.0	AN35A	Bolt		
Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)				
Bolt		⑥		
Pick:				
Qty	Part Number	Description	Batch	
8	AN3-5A	Bolt	M19356	M100188
18.0	AN523A	Bolt		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)				
Bolt		⑦		
Pick:				
Qty	Part Number	Description	Batch	
2	AN5-23A	Bolt	MPC9278	8/9/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 10:21:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BEAM ASSEMBLY
Job Number: 41268		Part Number: D3173041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
19.0	AN960JD10	Washer
Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)		
Washer		
Pick:		
Qty	Part Number	Description
8	AN960JD10	Washer
		M105442
		SP
20.0	AN960JD516	Washer
Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Washer		
Pick:		
Qty	Part Number	Description
4	AN960JD516	Washer
		M108672
		SP
21.0	MS21042L5	Nut
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Nut		
Pick:		
Qty	Part Number	Description
2	MS21042L5	Nut
		A1108161
		8/9/19
		SP
22.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
Assemble per Dwg D3173.		
Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.		
		EJ08/09/2022 (ex)
23.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
		S 08/09/2022 (t/c)
24.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		
Identify as D3173-041 and Pack with D130-701-041		
Location: Z02		
		8/9/23
		SP

W/O:		WORK ORDER CHANGES					
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 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: BEAM ASSEMBLY

Job Number: 41268

Part Number: D3173041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/24 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	41268
Description: Beam	Part Number:	D3173-1
Inspection Dwg: D3173	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>J.A</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	08/08/30	Date:	08/09/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3173-041	KJ/RF	TT



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. B D3173 SHEET 1 OF 3
DATE		TITLE SCALE 03.01.07 BEAM ASSEMBLY NTS
A	02.12.03	NEW ISSUE
B	03.01.07	REMOVE PIP PINS

PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3173-041	BEAM ASSEMBLY
1	D3173-1	BEAM
2	D3175-041	MOUNTING LUG
2	D3178-041	NUT PLATE
8	AN960JD10	WASHER
4	AN960JD516	WASHER
2	MS21042L5	NUT
8	MS20601AD4W4	RIVET
8	AN3-5A	BOLT
2	AN5-23A	BOLT

NOTES

D3173-1 BEAM:

- 1) PART IS SYMMETRICAL ABOUT CENTERLINE
- 2) MATERIAL: 6061-T6 RECTANGULAR TUBING, 4" x 2" x 0.125" WALL (QQ-A-200/8)
(REF DART SPEC. M6061T6TR4.0x2.0W125)
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 OUTSIDE ONLY
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

RELEASED
03.01.2008

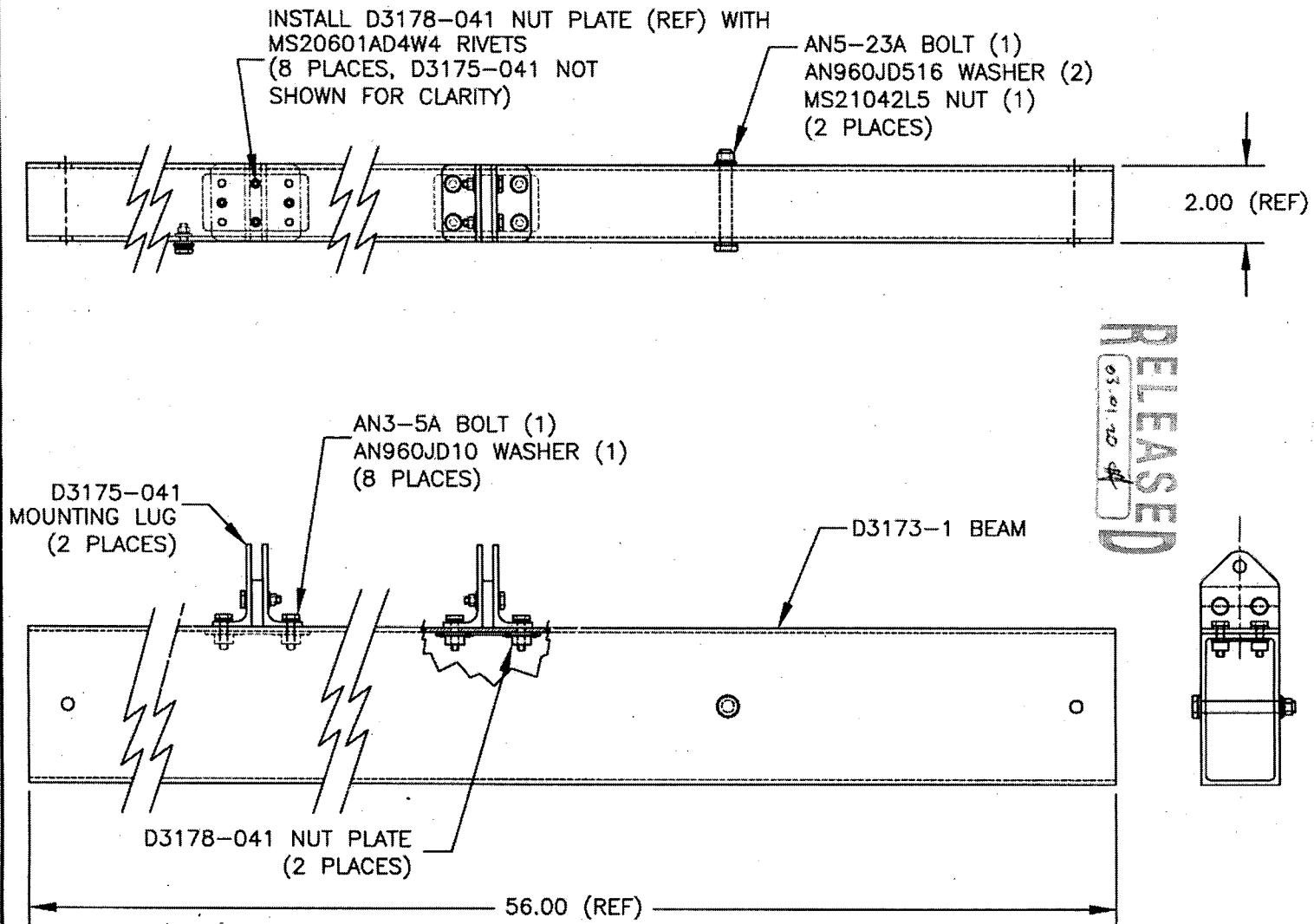
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CHECKED <i>MH</i>	APPROVED <i>MH</i>	HAWKESBURY, ONTARIO, CANADA		
		DRAWING NO.	D3173	REV. B
DATE		SHEET 2 OF 3		SCALE
03.01.07				1:4
TITLE BEAM ASSEMBLY				



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REV. B

DATE

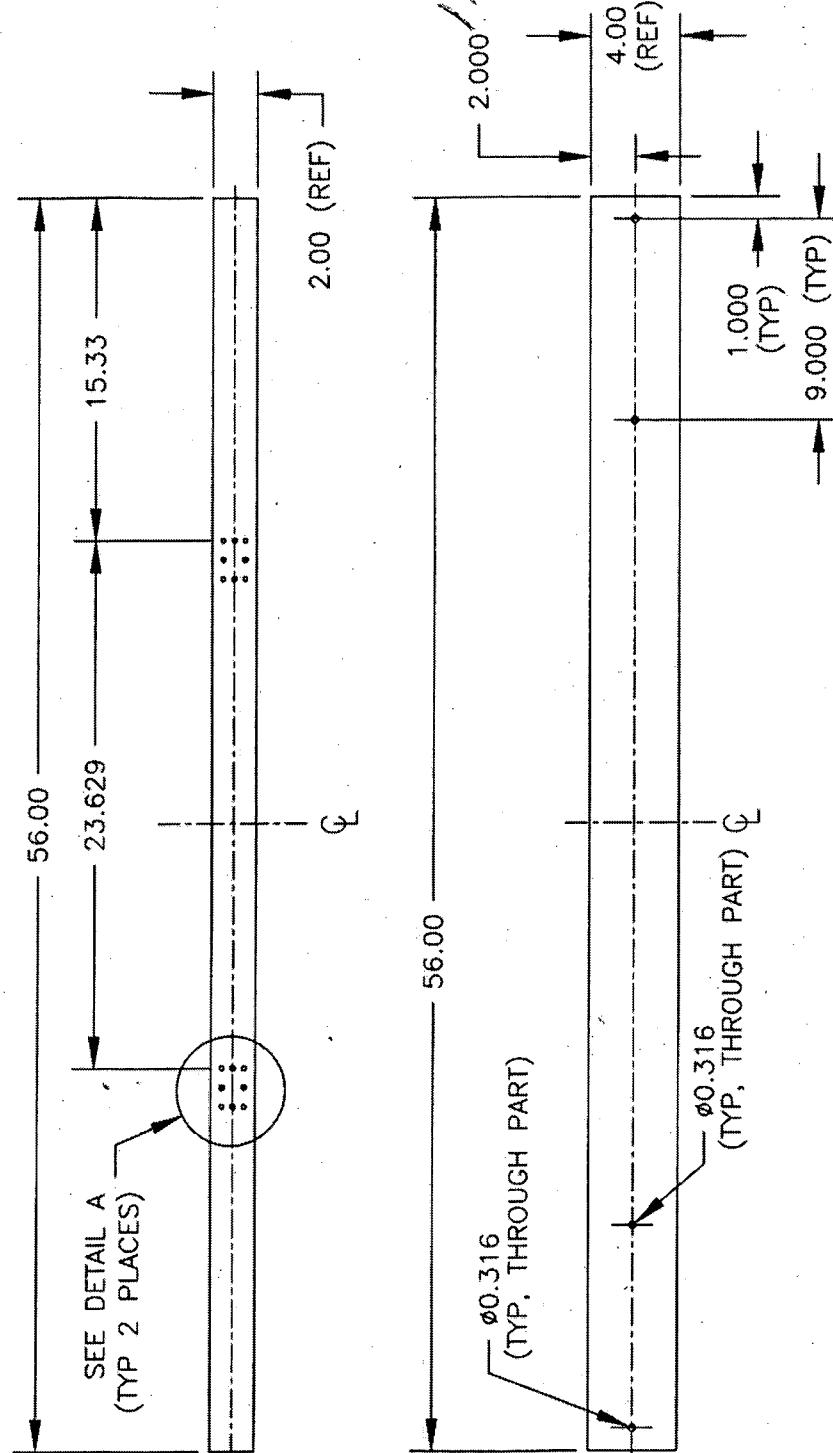
03.01.07

TITLE

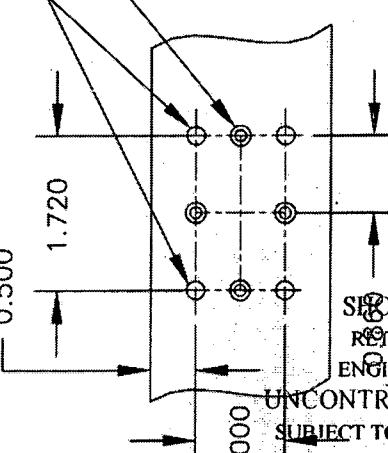
SHEET 3 OF 3

SCALE

1:8

**RELEASED**
03.01.07**DETAIL A**
SCALE 1:2

φ0.203 (TYP 8 PLACES TOTAL,
DRILL THIS SURFACE ONLY)
DRILL #30 (φ0.129)
C'SINK φ0.235x100.
(TYP 8 PLACES TOTAL,
DRILL THIS SURFACE ONLY)



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